

Date: Tuesday, 12/20/2005 3:37:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 25329	
Estimate Number : 10314	
P.O. Number : N/A	Part Number : D265613
This Issue : 12/20/2005 S.O. No. : N/A	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/20/2005 Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 24147	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/15/2006 Qty: 50 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER	
Comment : Est: F 02.10.25 Re-format KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 319

1-Email or ship DXF file to vendor

2-Laser Cut per Dwg D2656 flat pattern D2656-13

3-Material release note required

2.0

D265613F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

WEAR PLATE

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-13T1

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

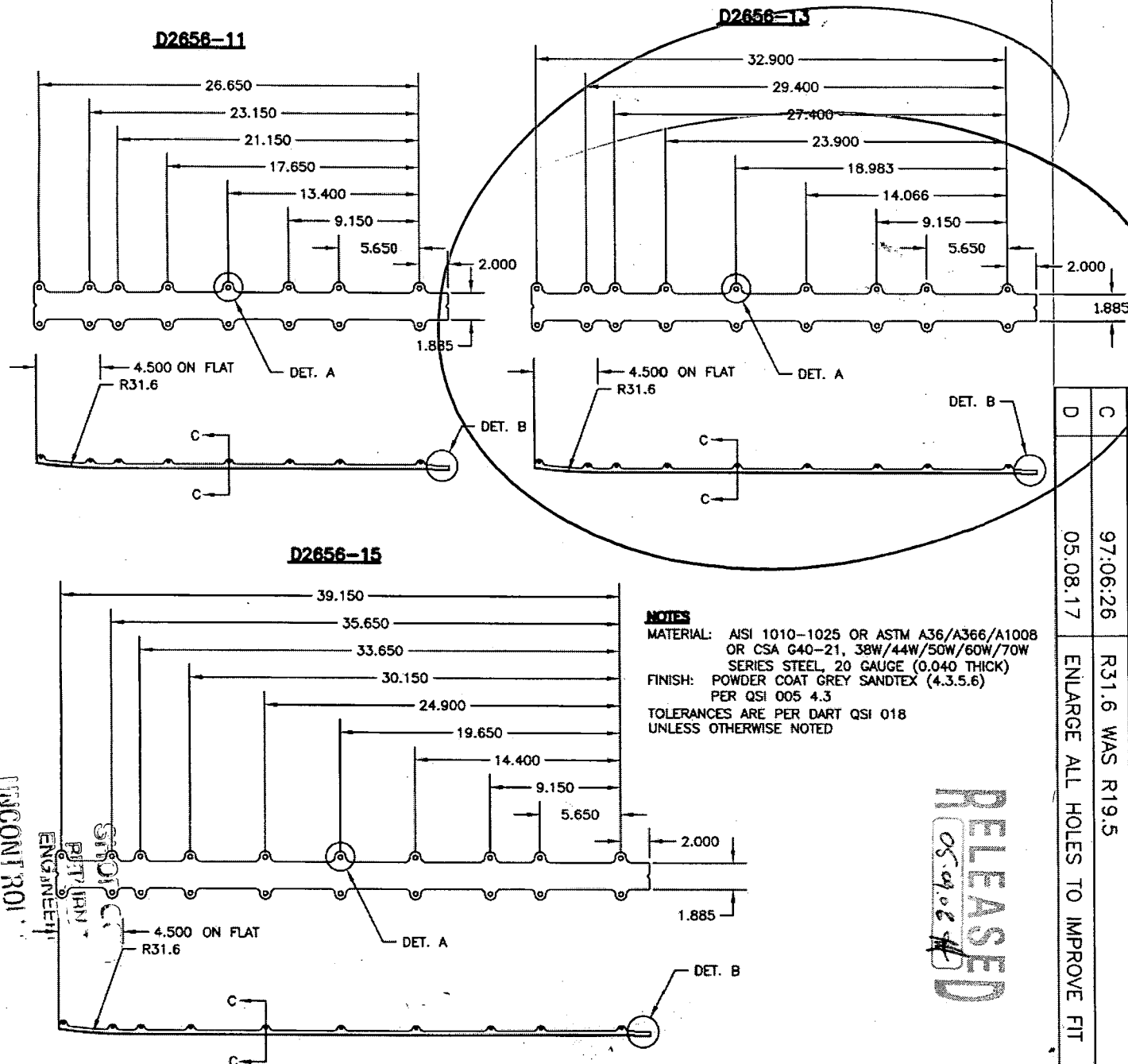
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. D
DS	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 4
#	#	D2656	
DATE	TITLE	SCALE	
05.08.17	WEARSHOE	1:10	
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

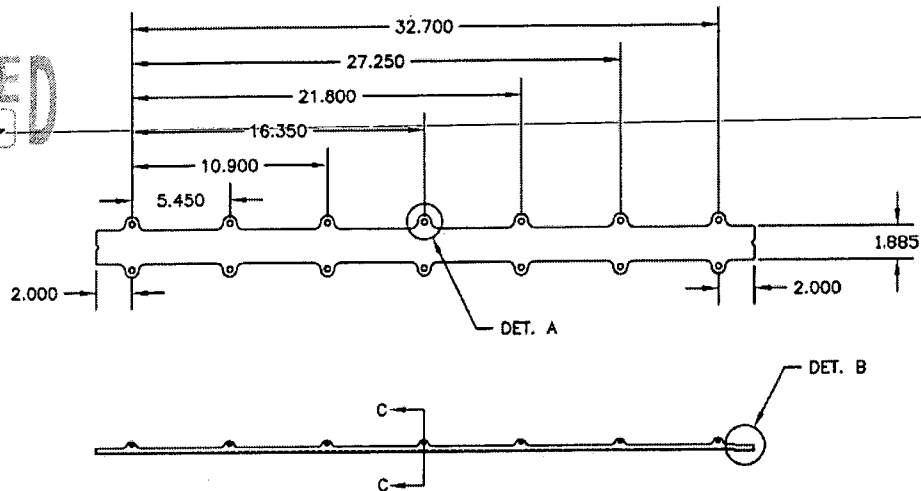




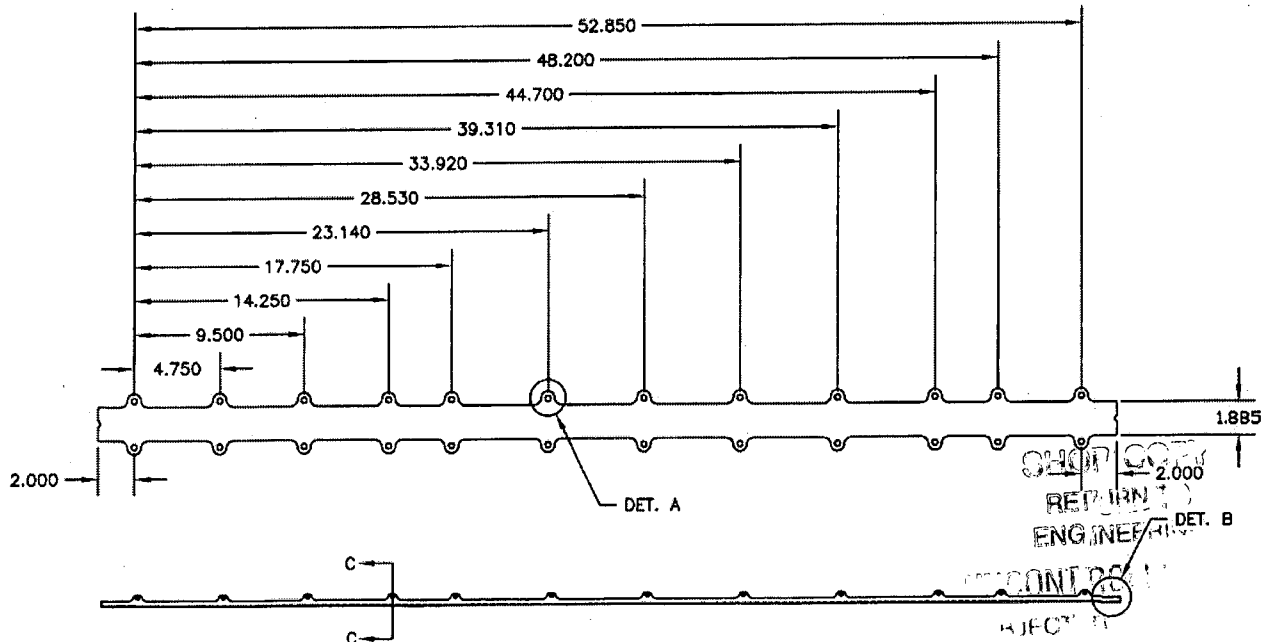
DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED
DS-07-06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

25329

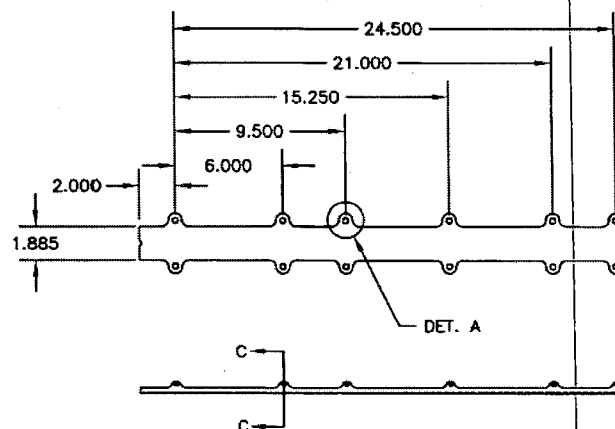
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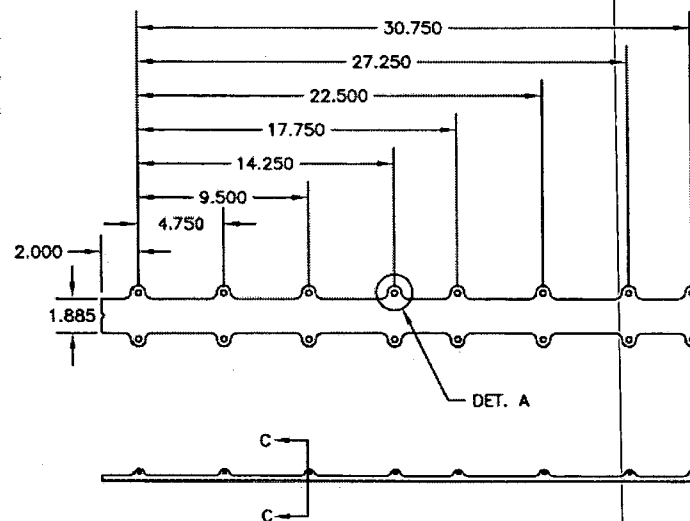


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DATE	05.08.17	TITLE	D2656	WEARSHOE
		REV. D	SHEET 3 OF 4	SCALE 1:10

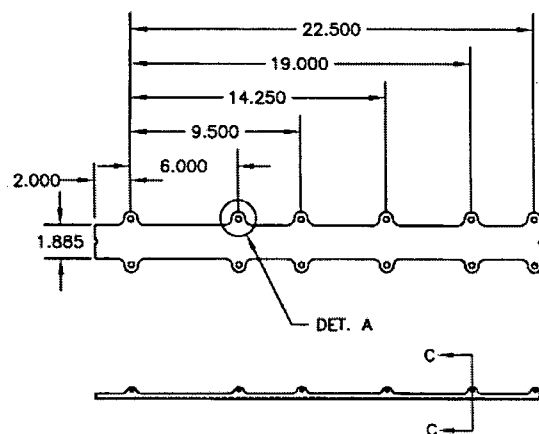
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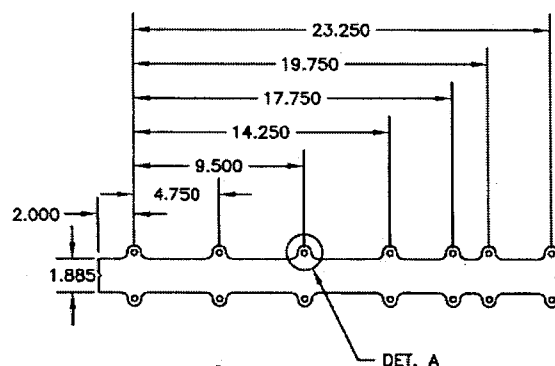
D2656-37



D2656-31



D2656-35



RELEASED
05-07-86

NOTES

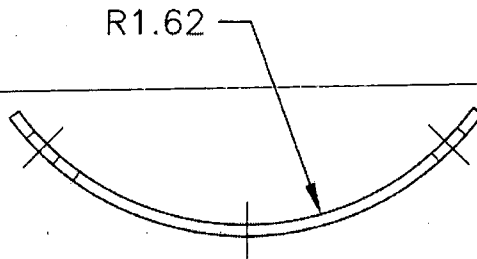
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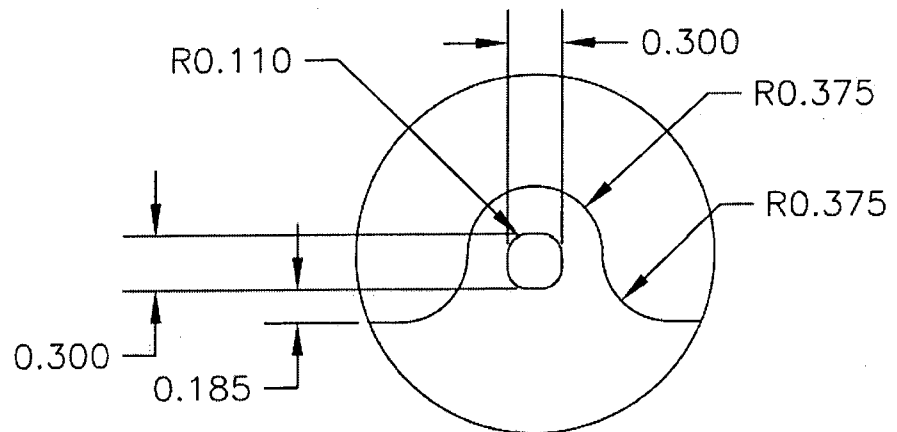
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

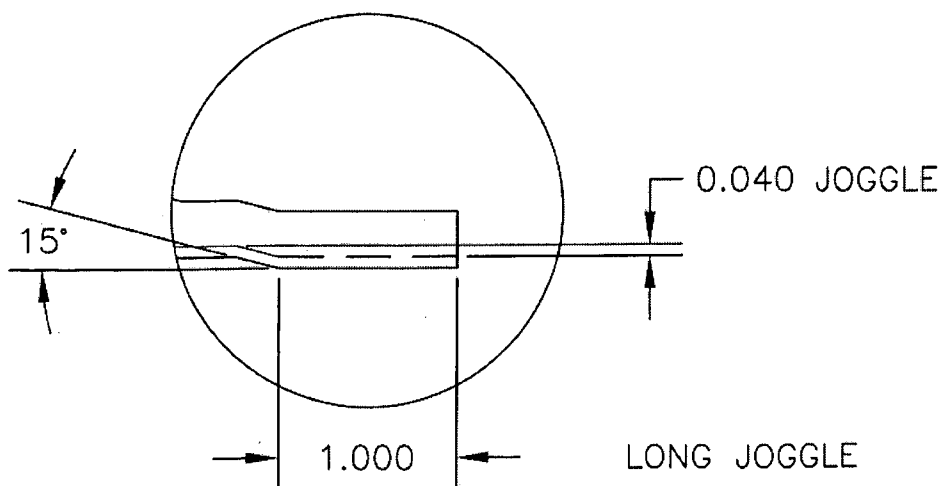


RELEASED
05.09.06

DETAIL A



DETAIL B



25329

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(06) 235 8069 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5135/22147

CUSTOMER	Wilkinson	P50224DI004	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC110913
CUSTOMER O/N	90-21N-597		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
ROLL O/N	475192		DIMENSIONS	0.033" x 48" x Coil	DATE	17 May 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)						
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	LENGTH
		x100					x1000					x10000					x100	180°			G.L.	HRB	()
R9-458541-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				52	2546
R9-458542-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				52	2766
R9-458543-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				53	2546
R9-458544-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				53	2779
R9-458545-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				51	2582
R9-458546-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				51	2677
R9-458547-00	641013	5	TR	20	11	17	12	17	24	2	8	1	1					Good				51	2582
R9-458548-00	641013	5	TR	20	11	17	12	17	24	2	8	1	1					Good				51	2582

P50202
P/O 319

YIELD	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=0	(C)=45	(A)=10mm x 10mm	(C)=5mm x 5mm	(A)=C+Mn/6	(C)=C+Mn/6+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 x 30	(F)=8"	(B)=90	(D)=(r0+90+2r45)/4	(B)=7.5mm x 10mm	(D)=2.5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Atish Misra
QC METALLURGIST

20 ga ms

